

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027044**Date Inspected:** 17-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Watson Bowman Acme**Location:** Amherst NY**CWI Name:** Reno Davis**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Expansion Joint**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI112667CA2 for the Seismic Expansion Joints on the SFOBB project. This QAI met with John Miller, QC Watson Bowman Acme (WBA), and Mr. Reno Davis QC, to discuss progress and any changes in schedule.

This QAI found the Channel Assembly SEI112667CA2-23 had been welded on second shift. All welding of the assembly was complete minus the attachment of the anchor studs. Run off tabs had been removed and some cleaning had taken place.

Jason Gray, WBA Welder, was observed welding on Channel Assembly SEI112667CA2-24. Mr. Gray is in the process of welding the side plate seams 1A, 1B, and 1C to the back plate, Top Plate and bottom plate. Approved WPS FCAW-13, (CJP for joint TC-U4b-F) being used for welding. All parameters monitored and verified by QC Mr. Davis and observed by this QAI. Run off tabs are in use. Back weld was put in and back gouged from face. This QAI observed the back gouging along with Mr. Davis, QC, and the seams were released for welding. Jason Gray is using Hobart (Tri-Mark) E81T1-Ni1 electrodes. Welding continues on joint under observation of this QAI.

The items observed appear to be progressing as scheduled and are in general conformance with the contract documents.

**Summary of Conversations:**

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC and WBA Personnel.

**Comments**

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## WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 858-531-0335, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sullivan, Kevin	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer

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